



Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADJUSTABLE ATTACHMENT ARM ASSY

Job Number: 40693

Part Number: PB674300159

Job Number:



Seq. #: Machine Or Operation: Description :

20.0 NAS1149F0332P WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

WASHER

batch: 18057

11/08/08

21.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- take -267 and transfer drill holes in -113 as per dwg PB67-43001

2- deburr and rivet -267 to -113 as per dwg

3- assemble rest of parts as per dwg PB67-43001

11/08/08

22.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP



23.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

11/08/08

(X)



24.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



Job Completion



WT  
08-10-08



Tuesday, 22/07/2008 8:49:18 AM

Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADJUSTABLE ATTACHMENT ARM ASSY

Job Number: 40693

Part Number: PB674300159

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0 PB6743001267

PB67-43001-267



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

PB67-43001-267

batch: 340095



12 08-08-06

14.0 PB6743001121

Square Sleeve



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Square Sleeve

batch: 340612



for  
done to only  
no split

12 08-08-06

15.0 BSP43

RIVET



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

RIVET

batch: 178690



12 08-08-06

16.0 MS17984C413

PIN, QUICK RELEASE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

PIN, QUICK RELEASE

batch: 108826



12 08-08-06

17.0 30345T21

LANYARD



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

LANYARD

batch: 102862



12 08-08-06

18.0 MS27039122

SCREW



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

SCREW

batch: 18057



12 08-08-06

19.0 MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

batch: 108864



12 08-08-06



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ADJUSTABLE ATTACHMENT ARM ASSY

Job Number: 40693

Part Number: PB674300159

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 M6061T6T1750W065

6061T6 RDTUBE 1.750 X 0.65W -



Comment: Qty.: 0.1575 f(s)/Unit Total : 0.7875 f(s)

6061T6 RDTUBE 1.750 X 0.65W

batch: M18188

SP 08-07-31 - ~~08-08-06~~

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: 1- to make -105 take M6061T6 tube and fabricate to fit contour of cut

2- Weld -105 to -113 as per dwg and grind weld flush → NOT READ THIS PATCH ONLY TO AVOID CRACKING

3- weld 119, -117 and -115 to -113 as per dwg PB67-43001

4- pick two -271 and weld one on each side of tubing but only one need to be trim to fit on -113 as per dwg

PB67-43001

SP 08-08-06 4X

8.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

D 08-08-01 4X

9.0 QC5

INSPECT WORK TO CURRENT STEP

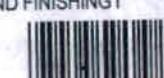


Comment: INSPECT WORK TO CURRENT STEP

S 08/08/07 4X

10.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.F.

08/08/08

4X

11.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

4X

1- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

9:15

OVEN TEMPERATURE:

320

FINISH TIME:

9:45

M.F.

08/08/08

12.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-08

4X



## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: ADJUSTABLE ATTACHMENT ARM ASSY		
Job Number	: 40693 -1			Part Number	: PB674300159		
Estimate Number	: 13479			Drawing Number	: B6743001 P.14		
P.O. Number	:			Project Number	: N/A		
This Issue	: 22/07/2008	S.O. No.	:	Drawing Revision	: B1		
Prsht Rev.	: NC			Material	:		
First Issue	: 11	Type	: LARGE FAB ASSY	Due Date	: 29/07/2008		
Previous Run	:			Qty:			
Written By	:			Um:	Each		
Checked & Approved By	: MF 08-07-23.						
Comment	: Est Rev:A 08-07-18 new issue DD verified by:ec						
Additional Product							
Job Number: 							
Seq. #:	Machine Or Operation:	Description :					
1.0	PB6743001113	Square Tubing 					
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Square Tubing batch: B400599 * 3 SP 310537 * 1 							
2.0	PB6743001119	End Cap Clevis 					
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) End Cap Clevis batch: B400110 ✓ SP 08-07-31 							
3.0	PB6743001117	Hook Plate 					
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Hook Plate batch: B400151 ✓ SP 08-07-31 							
4.0	PB6743001115	Tube End Plate 					
Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s) Tube End Plate batch: B40014 ✓ SP 08-07-31 							
5.0	PB6743001271	Doubler 					
Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s) Doubler batch: B40058 . ✓ SP 08-08-6 